

Date: Wednesday, 2/20/2008 4:21:20 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LOW PROFILE BASKET LID ASS'Y
 Job Number : 37527
 Estimate Number : 13153
 P.O. Number :
 This Issue : 2/20/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LARGE FAB ASSY
 Previous Run : 37526
 Part Number : D3713042
 Drawing Number : D3713 U/R
 Project Number : N/A
 Drawing Revision : U/R
 Material :
 Due Date : 3/10/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A new issue 08-01-30 DD verified by:EC

POSITIVE
RECALL

08.03.12

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 32.5731 f(s)/Unit Total : 32.5731 f(s)
 304 SQ Tube.75x.75x.065W

1- Cut Ribs as per dwg from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.

QTY	PART NUMBER	BATCH
2	D3714-1	M107038
2	D3715-1	M107038
10	D3716-1	M107038
4	D3732-1	M107038

2- Deburr

dy 08/02/26

2.0 D23271 : Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Spacer Bushing
 batch B36920

dy 08/02/26

3.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Mounting Bracket
 batch B36481V

Pl 08-03-04

4.0 D37491 HINGE HALF



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
 HINGE HALF
 batch B37202V

Pl 08-03-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:21:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOW PROFILE BASKET LID ASS'Y

Job Number: 37527

Part Number: D3713042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2329

Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Label Plate

batch B35680 ✓

CP 08-03-04

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- drill holes in both D3715-1 as per dwg D3715

2- deburr

3- assemble as per dwg D3713 and weld as per QSI004

CP 08-03-10

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-03-10

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 08-03-10

9.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 17.8500 sf(s)/Unit Total : 17.8500 sf(s)

Expanded Metal Flat Stainless Steel

Pick:

Qty Part Number Description
17sq.ft M304EX0.75-16F Expanded Metal

Batch

M104798 ✓

CP 08-03-04

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- cut mesh as per dwg D3743

2- weld mesh as per dwg D3713

CP 08-03-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: 19 Date: 08/03/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:21:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOW PROFILE BASKET LID ASS'Y

Job Number: 37527

Part Number: D3713042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



ASS

ENGINEERING



Comment: INSPECT WORK TO CURRENT STEP

08.03.12

APPROVAL

08/03/12 (X)

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-03-12

13.0

POWDER COATING

POWDER COATING



M100700



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

08/03/13 (P)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08/03/13 (IX)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M106894



Comment: Wing Walk as per Dwg D3713 and QSI 005 4.4

M-1 08/03/13 (IX)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-13 (X)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

M 08/03/14

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/14

Job Completion



POSITIVE RECALL
POSITIVE RECALL

EFFECTIVE 08.02.21

RELEASED

AUTH

DATE

08.02.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

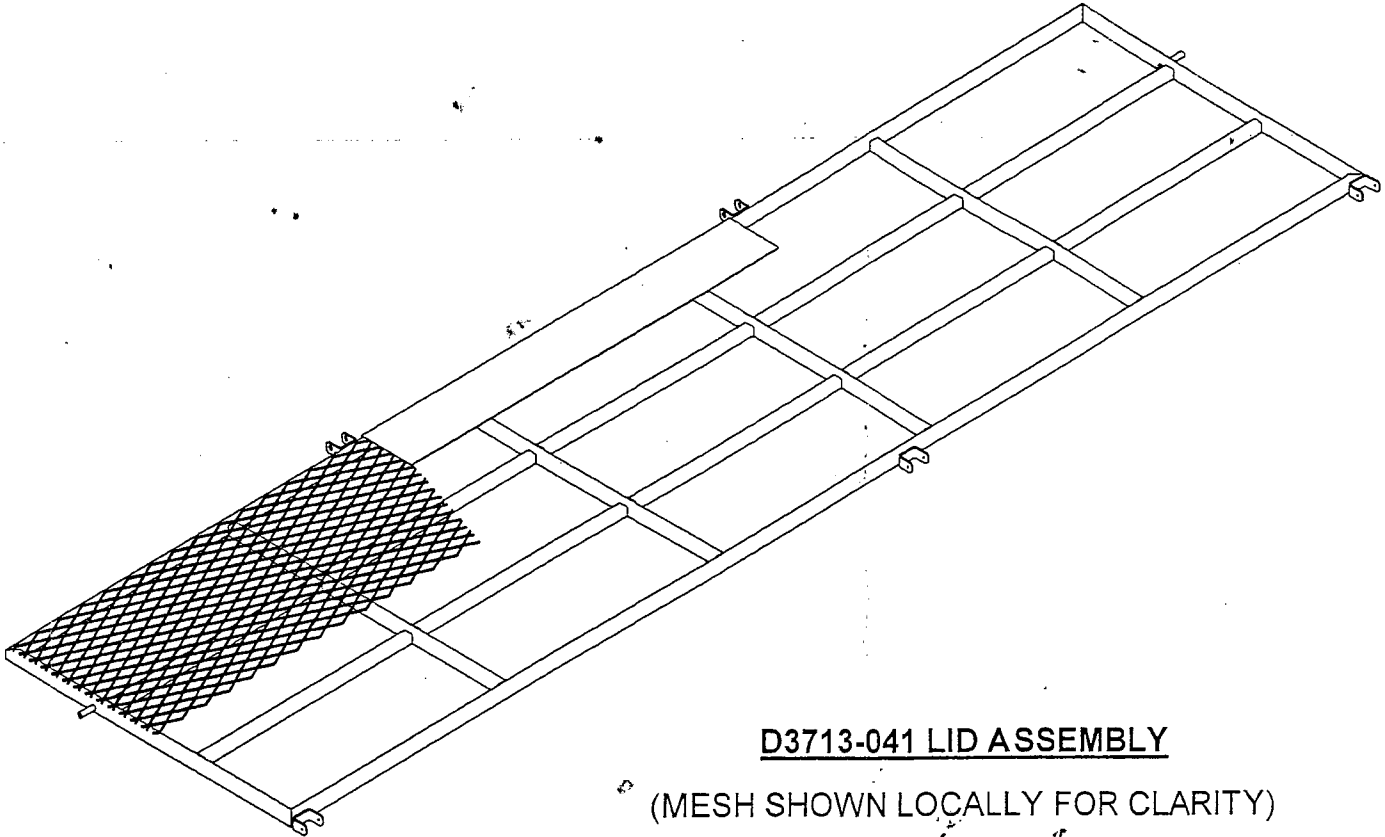
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY.	PART NUMBER	DESCRIPTION
X	D3713-041	LID ASSY LOW PROFILE BASKET
2	D2327-1	SPACER
1	D2329	LABEL PLATE
2	D2581	MOUNTING BRACKET
2	D3714-1	RIB
2	D3715-1	RIB
10	D3716-1	RIB
4	D3732-1	RIB
1	D3743-1	MESH
3	D3749-1	HINGE HALF



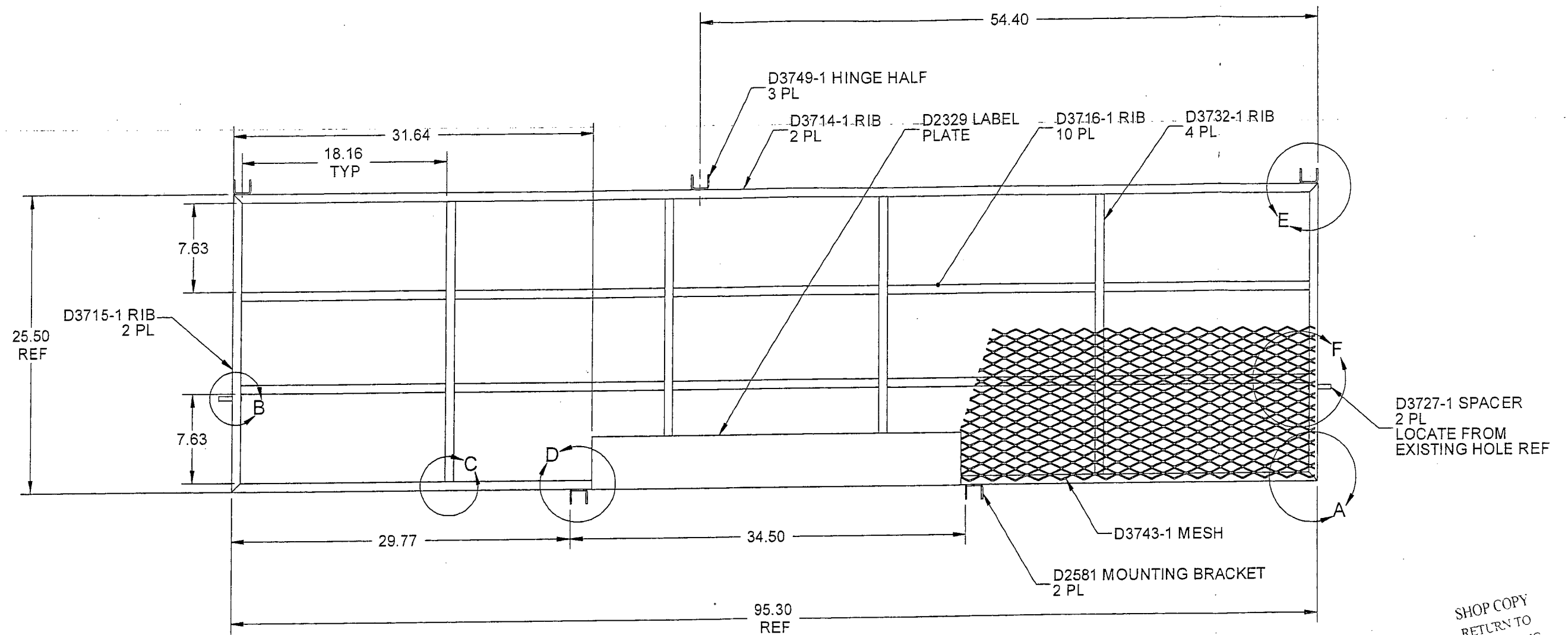
D3713-041 LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37527

PRELIMINARY ISSUE
UE 08.02.15

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 36 lbs APPROX.
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	AJS	08.02.01
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	UE	DRAWING NO.	REV. A
MFG. APPR.		D3713.	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.	UE	LID ASSEMBLY	NTS
DATE	08.02.01	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

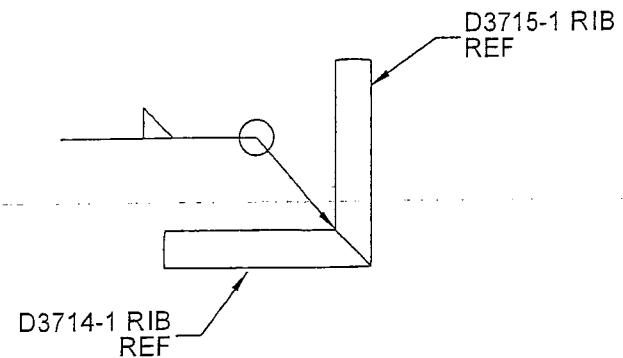


D3713-041 LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

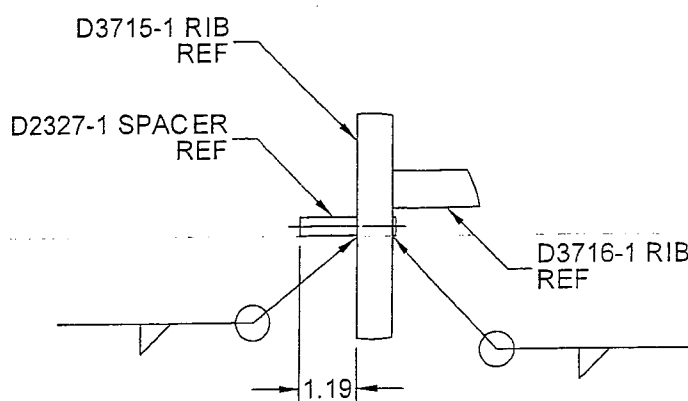
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PRELIMINARY ISSUE
6E 08.02.15

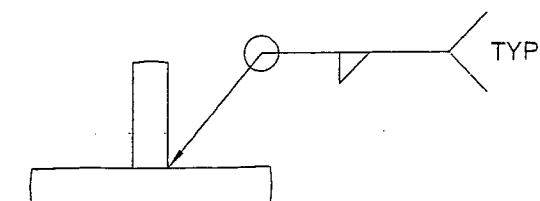
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	6E	DRAWING NO. D3713	REV. A
MFG. APPR.		SHEET 2 OF 3	
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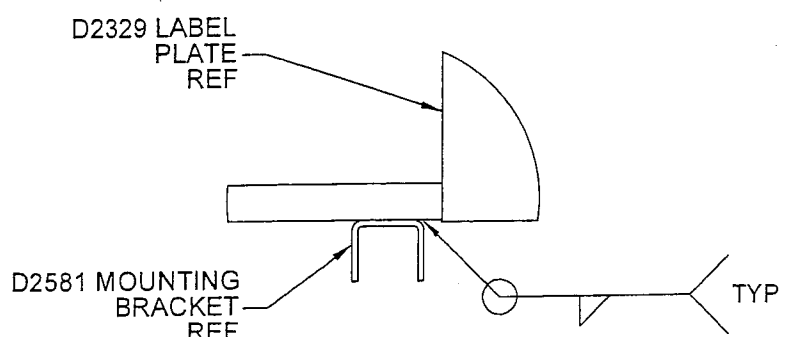
DETAIL A: TYP CORNER WELDS
SCALE 4X
(MESH NOT SHOWN FOR CLARITY)



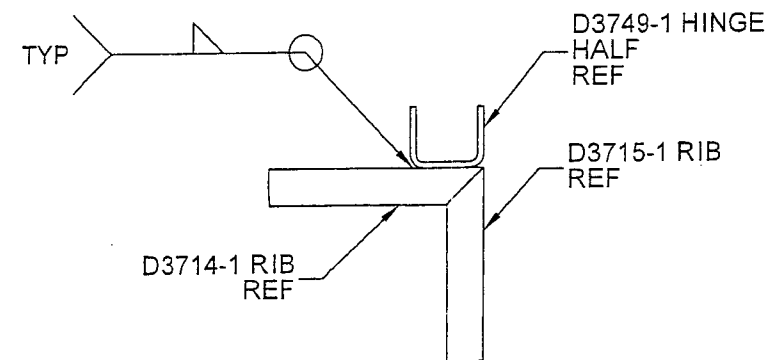
DETAIL B
TYP BOTH ENDS
SCALE 4X



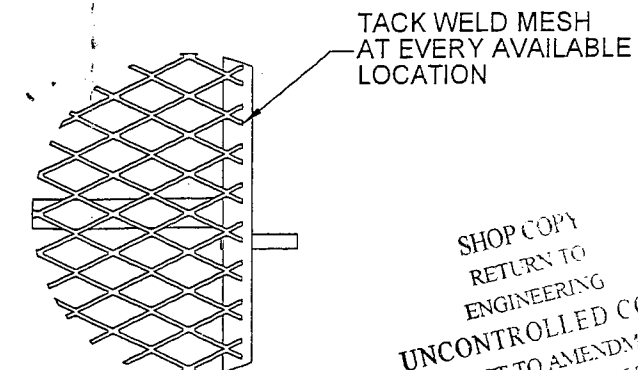
DETAIL C
TYP
SCALE 4X



DETAIL D
SCALE 4X



DETAIL E
SCALE 4X



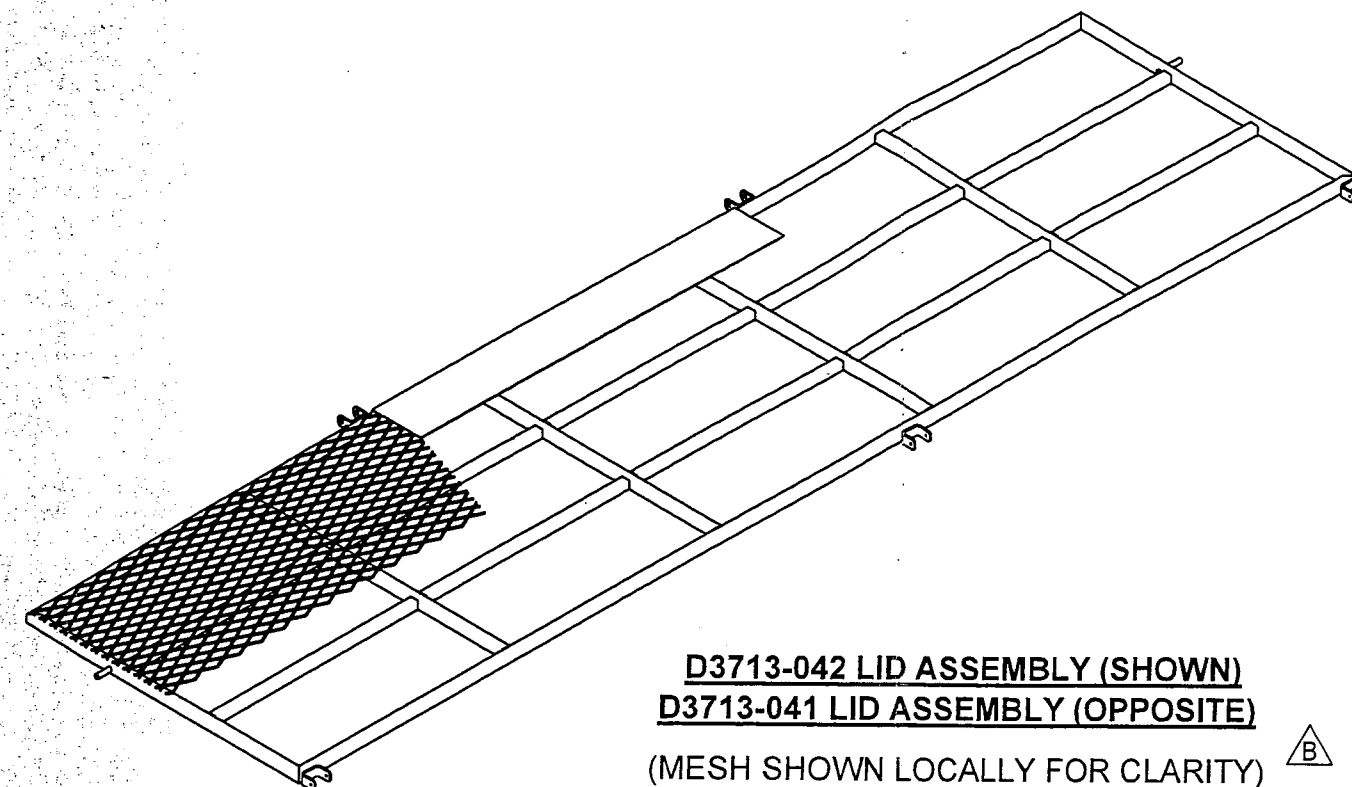
DETAIL F
SCALE 5X

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PRELIMINARY ISSUE
08.02.15

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.		D3713	SHEET 3 OF 3
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QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3713-041	LID ASSEMBLY
	X	D3713-042	LID ASSEMBLY
2	2	D2327-1 ✓	SPACER
1	1	D2329 ✓	LABEL PLATE
2	2	D2581 ✓	MOUNTING BRACKET
2	2	D3714-1 ✓	RIB
2	2	D3715-1 ✓	RIB
10	10	D3716-1 ✓	RIB
4	4	D3732-1 ✓	RIB
1	1	D3743-1 ✓	MESH
3	3	D3749-1 ✓	HINGE HALF

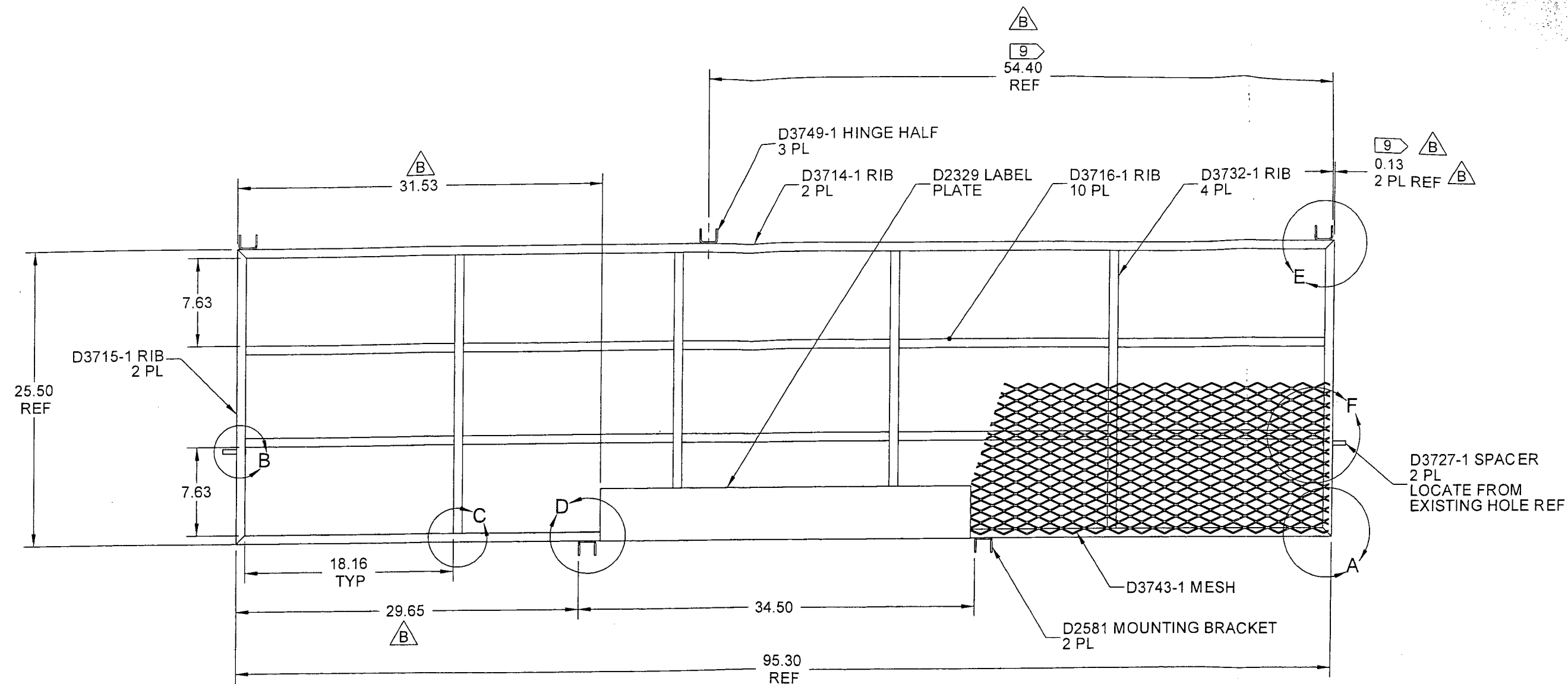


D3713-042 LID ASSEMBLY (SHOWN)
D3713-041 LID ASSEMBLY (OPPOSITE)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

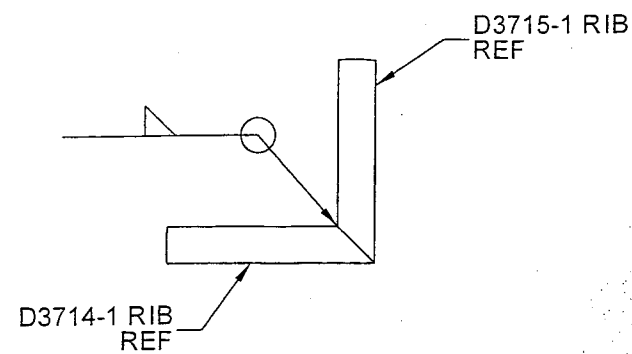
- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF ON D3712-041/042 BASKET BASE ASSEMBLY

B	SHEET 1 -042 WAS -041; ADDED CORRECT -041 ASSEMBLY, NOTE 9 ADDED, ZONE C2 LID ASSEMBLY WAS D3713-041. WEIGHT WAS 36 lbs. SHEET 2 ZONE B5 LID ASSEMBLY WAS D3713-041, ZONE D6 31.53 DIM WAS 31.64, ZONE D3 54.40 DIM NOW REF ZONE D2 0.13 REF DIM ADDED ZONE B6 29.65 DIM WAS 29.77, ZONE D3 & D2 FLAG NOTE 9 ADDED.	AJS	08.02.27
A	NEW ISSUE	AJS	08.02.01
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	CE	DRAWING NO.	REV. B
MFG. APPR.	DS	D3713	SHEET 1 OF 3
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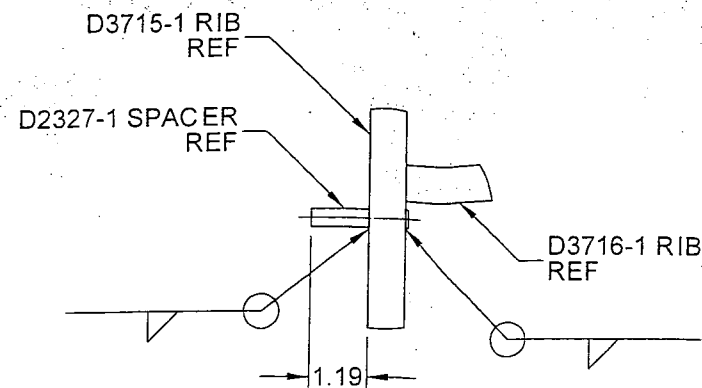


D3713-042 LID ASSEMBLY (SHOWN) B
D3713-041 LID ASSEMBLY (OPPOSITE)
 (MESH SHOWN LOCALLY FOR CLARITY)

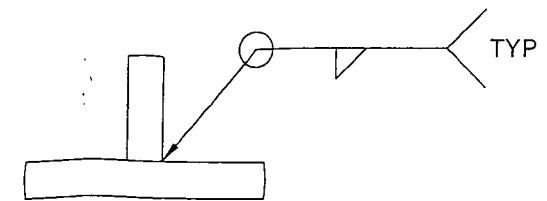
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
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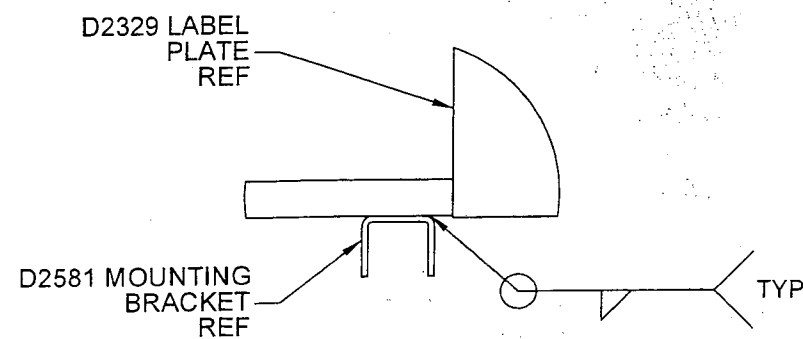
DETAIL A: TYP CORNER WELDS
SCALE 4X
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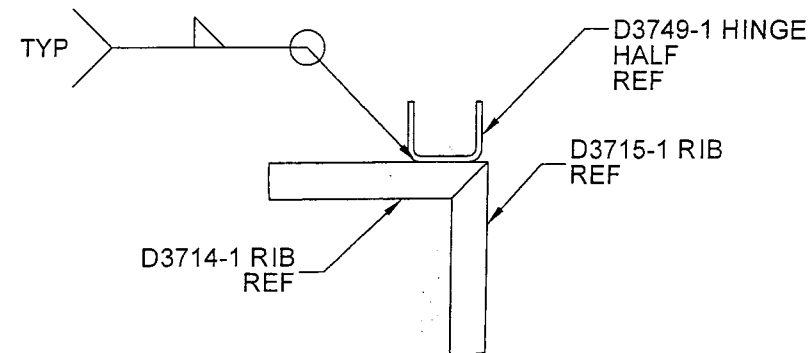
DETAIL B
TYP BOTH ENDS
SCALE 4X



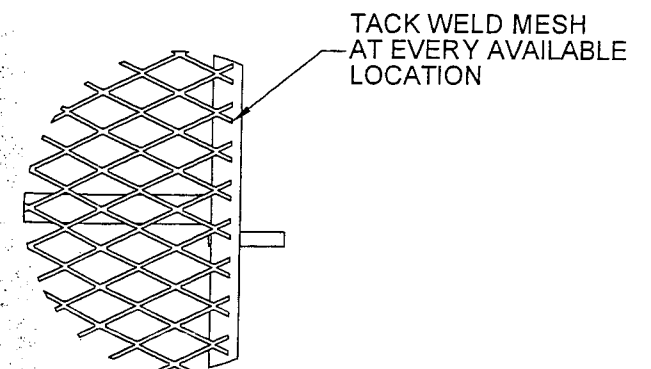
DETAIL C
TYP
SCALE 4X



DETAIL D
SCALE 4X



DETAIL E
SCALE 4X



DETAIL F
SCALE 5X

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. B
MFG. APPR.	AD	D3713	SHEET 3 OF 3
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DE APPR.	TH	LID ASSEMBLY	NTS
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